

6094



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18520-9
Job Sheet 181556



2-5



45

7-31

Part No: RBT18520-9

Job Qty: 8 ea

Part Name: Extension



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 7/31/18

Job Tracking No:

Due Date: 8/7/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT18520-9 REV:11 IPP REV A 18.02.06 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	8/7/18	8/7/18	0.00	0.00	Start Up Machining-4		
120	Lathe Conv	8 pcs	8/7/18	8/7/18	0.25	1.00	Lathe Conv-2		
130	QC	8 pcs	8/7/18	8/7/18	0.00	0.00	QC2 Machining-5		
140	QC	8 pcs	8/7/18	8/7/18	0.00	0.00	QC8 Machining-5		
142	HandFinish	8 pcs	8/7/18	8/7/18	0.00	2.00	HandFinish7		
143	QC	8 pcs	8/7/18	8/7/18	0.00	0.00	QC5		
150	Outsource	8 pcs	8/7/18	8/7/18			GRO002-VC	10	
160	Packaging	8 pcs	8/7/18	8/7/18	0.00	0.00	Packaging2		
170	QC	8 pcs	8/7/18	8/7/18	0.00	0.00	QC6		
180	Packaging	8 pcs	8/7/18	8/7/18	0.00	0.00	Packaging3-2		
190	QC21-SA	8 Ea	8/7/18	8/7/18	0.00	0.00	QC21		

Part Op 142 - Remove scale

Descriptions: 150 - Issue P/O to Groupe Altech; PO 0-10899 - Black oxide finish, MIL-C-13924C Class 1 - Certificate of Conformity is required

160 - Receive

180 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
7767T61	Low-Carbon Steel Round Tube, 0.188" Wall Thickness, 3/4" OD 8.3328 ft (1.0416 ea)	90-Start up Operation		50543464
				50543464

3x
5x

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	7767T61	8	14	0

Part Specifications

Specifications could not be found.

Plex 7/31/18 1:47 PM dart.logan.david



Container No: S106433



Part: RBT18520-9

Job No: 181556

Serial No/Batch: S106433

Revision: 11

Inspector:

Exp Date:

Instructions:

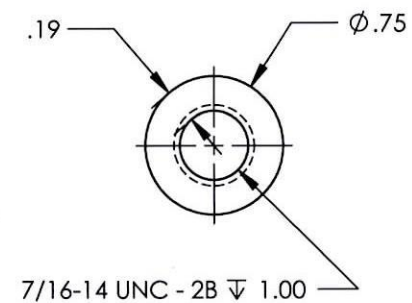
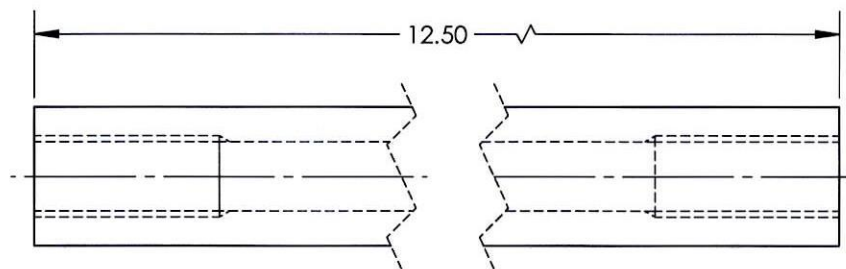
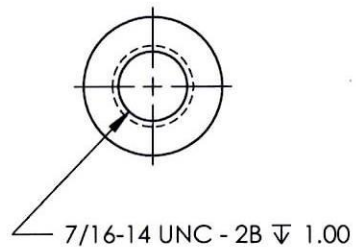
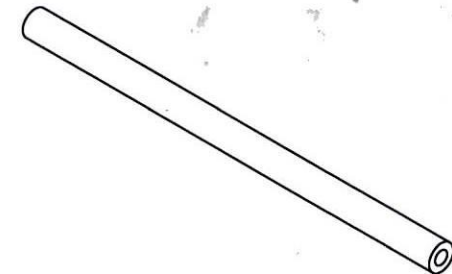
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/29/18

2018
08
63

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
10	16-0096	-9 CH'D DIM WAS .188 WALL IS .19.	8/4/2016	DPD	JAG



(-9)
EXTENSION

DART AEROSPACE	
TITLE ROTOR DAMPER TEST DEVICE	
DWG NO. RBT18520-9	REV 11
MAT'L CDS HEAT TREAT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS $\pm 1/8$
FINISH BLACK OXIDE	.XXX $\pm .010$.XX $\pm .03$.X $\pm .1$
SPEC QMSI-6.2.2 REV D	ANGLES $\pm 1^\circ$ SURFACES = 125/
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:1	DATE 8/17/2000
SHEET 9 OF 17	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																																	
Description Work Order Deviation		Disposition		Completed By																																																																	
				Lead hand / Supervisor Approval Verification																																																																	
				QC / QA Coordinator Approval																																																																	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040899**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040899
PO Date: 8/30/18
Due Date: 9/6/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181846-A	RBE350A94-3701-00-03	6° Main Rotor Rigging Tool (Dual) -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	9/6/18	1 pcs	0 pcs	1 pcs	\$120.00/pcs	\$120.00

~~SEP 06 2018~~

1 X SEP 07 2018



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PURCHASE ORDER

PO040899

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	181727	RB AN8516-1-PO	1/2" Drive Adjustment Spanner -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	9/6/18	3 pcs	0 pcs	3 pcs	\$8.50/pcs	\$25.50
Line Item Note ** rush part, please prioritize this part over others **											
3	182724	RBT18520-5	Weldment -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	9/6/18	2 pcs	0 pcs	2 pcs	\$2.25/pcs	\$4.50
4	181556	RBT18520-9	Extension -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	9/6/18	8 pcs	0 pcs	8 pcs	\$4.35/pcs	\$34.80
5	181127	RBE350A94-2706-00-05	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	9/6/18	24 pcs	0 pcs	24 pcs	\$2.40/pcs	\$57.60



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PURCHASE ORDER

PO040899

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	181341	RBEM633V3000124-3	Nut -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	-	9/6/18	6 pcs	0 pcs	6 pcs	\$15.00/pcs	\$90.00
7	178185	RBEM632V3011101-1	Plier Half -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 1018 -Certificate of Conformity is required	Firmed	-	9/6/18	8 pcs	0 pcs	8 pcs	\$11.25/pcs	\$90.00
8	177796	RBEM652V3002101-M-9	Bar Handle Nut -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	9/6/18	8 pcs	0 pcs	8 pcs	\$1.85/pcs	\$14.80
Grand Total:											\$437.20



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PURCHASE ORDER PO040899

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/6/18 3:56 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(012322-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

012322 - 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
06-Sep-2018		Aman		040899				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A94-3701-00-03-A Rev. 181846A	RBE350A94-3701-00-03-A 01-ANO-BLACK [ANODIZE BLACK] TYPE 2 CLASS 2 MIL-A-8625F	ANODIZE LOT	1	1	0	0	0
2	RB AN8516-1-PO Rev. 181727	RB AN8516-1-PO 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 IT IS KITS NOT SINGLE	BLACK-OXIDE CH	3	3	0	0	0
3	RBT18520-5 Rev. 182724	RBT18520-5 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	2	2	0	0	0
4	RBT18520-9 Rev. 181556	RBT18520-9 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	8	8	0	0	0
5	RBE350A94-2706-00-05 Rev. 181127	RBE350A94-2706-00-05 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	24	24	0	0	0
7	RBEM632V3011101-1 Rev. 178185	RBEM632V3011101-1 01-ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2 SC2 MATERIAL TYPE 1018	ZINC CH	8	8	0	0	0
8	RBEM652V3002101-M-9 Rev. 177796	RBEM652V3002101-M-9 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	8	8	0	0	0

DAS
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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.